



Dart Aerospace Ltd.
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Canada

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New copy
03 added
19.01.16
u

RBE105-14101W11
Job Sheet 185440



Part No: RBE105-14101W11

Job Qty: 5 ea

Part Name: Retention Bolt Extraction Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14101W11 Rev.B IPP Rev. A 18.10.19 New issue DP Verify DD/IPP Rev. B 19.01.16 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	5 Ea		11/16/18	0.00	0.00	Start Up Machining-4			
120	Lathe Conv	5 pcs		11/16/18	0.00	1.25	Mill Conv 2			
130	QC	5 pcs		11/16/18	0.00	0.00	QC2 Machining-5			
140	QC	5 pcs		11/16/18	0.00	0.00	QC8 Machining-5			
142	Outsource - 12 - Black Oxide	5 pcs		11/16/18			GRO002-VC			
144	Packaging 2-1 - Receive - B4B	5 pcs		11/16/18	0.00	0.00	Packaging 2 - 1 - B4B			
146	QC 6	5 pcs		11/16/18	0.00	0.00	QC 6 - 38			
150	Small Fab	5 pcs		11/16/18	0.00	0.63	Small Fab-6			
155	Conventional Mill - 1 - B4B	5 pcs		11/16/18	0.00	0.00	Conventional Mill - 1 - B4B			
156	QC 2	5 pcs		11/16/18	0.00	0.00	QC 2 - 1			
160	QC 8	5 pcs		11/16/18	0.00	0.00	QC5			
170	Packaging	5 pcs		11/16/18	0.00	0.00	Packaging3-2			
180	QC21-SA	5 Ea		11/16/18	0.00	0.00	QC21			

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Part Op 120 - ***Cut bar to _____ **** 1-Machine as per DWG. 2-Deburr
Descriptions: 142 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1144 -Certificate of Conformity is required
150 - 1-Form bar as per DWG.
155 - 1-Machine as per DWG 2-Cut to final dimension
160 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
170 - IDENTIFY AND STOCK

5 ea cancelled
W2411 change
per ECN

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6628K23	1144 Carbon Steel Rod, Ultra Strength, 1/4" Dia.	5 ft (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	6628K23	5	12	0

Part Specifications

Specifications could not be found.

Plex 1/16/19 11:31 AM dart.lacelle.linda



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RBE105-14101W11
Job Sheet 185440



Part No: RBE105-14101W11

Job Qty: 5 ea

Part Name: Retention Bolt Extraction Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14101W11 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		11/16/18	0.00	0.00	Start Up Machining-4		
120	Lathe Conv	5 pcs		11/16/18	0.00	1.25	Mill Conv 2		SEE Next page
130	QC	5 pcs		11/16/18	0.00	0.00	QC2 Machining-5		
140	QC	5 pcs		11/16/18	0.00	0.00	QC8 Machining-5		
150	Small Fab	5 pcs		11/16/18	0.00	0.63	Small Fab-6		
155	Mill Conv	5 pcs		11/16/18	0.00	0.00	Conventional Mill - 1 - B4B		
156	QC 2	5 pcs		11/16/18	0.00	0.00	QC 2 - 1		
160	QC 8	5 pcs		11/16/18	0.00	0.00	QC5		
170	Packaging	5 pcs		11/16/18	0.00	0.00	Packaging3-2		
180	QC21-SA	5 Ea		11/16/18	0.00	0.00	QC21		

Part Op 120 - ***Cut bar to 12.00 **** 1-Machine as per DWG. 2-Deburr
Descriptions: 150 - 1-Form bar as per DWG.
155 - 1-Machine as per DWG 2-Cut to final dimension
170 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5836T215	Tight Tolerance 4140 Alloy Steel Rod, 6mm Dia.,	5 ft (1 ea)	90-Start up Operation	<u>5122612</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	5836T215 <u>6628K23</u>	5	1	0

Part Specifications

Specifications could not be found.

Plex 11/5/18 11:23 AM Dart.lajeunesse.marie

1/4" 1144 carbon steel rod
6628K23 (6ft Lg) (X2)

DAS
03
4-98

DOA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



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RBE105-14101W11
Job Sheet 185440



7314
Nov-12

Part No: RBE105-14101W11

Job Qty: 5 ea

Part Name: Retention Bolt Extraction Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14101W11 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-4		FRED 18-11-2
120	Mill Conv	5 pcs	11/16/18	11/16/18	0.00	1.25	Mill Conv 2		FRED 18-11-2
130	QC	5 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-5		FRED 18-11-2
140	QC	5 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-5		
150	Small Fab	5 pcs	11/16/18	11/16/18	0.00	0.63	Small Fab-6		
160	QC	5 pcs	11/16/18	11/16/18	0.00	0.00	QC5		
170	Packaging	5 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2		
180	QC21-SA	5 Ea	11/16/18	11/16/18	0.00	0.00	QC21		

Part Op 120 - ***Cut bar to 12.00**** 1-Machine as per DWG. 2-Deburr

Descriptions: 150 - 1-Form bar as per DWG. Ensure proper positioning. 2-Trim to final dimension. 3-Deburr. 4-Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

170 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5836T215	Tight Tolerance 4140 Alloy Steel Rod, 6mm Dia.,	5 ft (1 ea)	90-Start up Operation	5122612

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	5836T215	5	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Plex 10/26/18 11:23 AM Dart.lajeunesse.marie

Container No: S124252



Part: RBE105-14101W11

Job No: 185440

Serial No/Batch: S124252

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 11/02/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

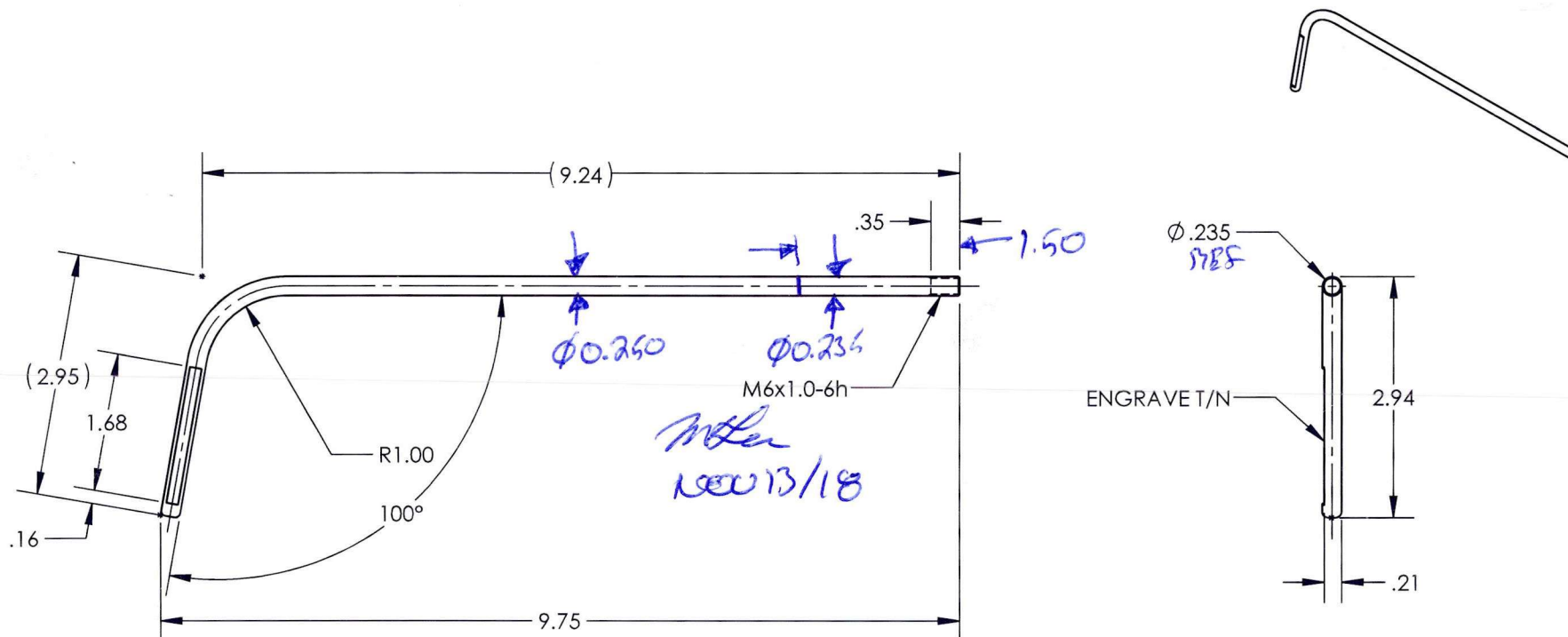
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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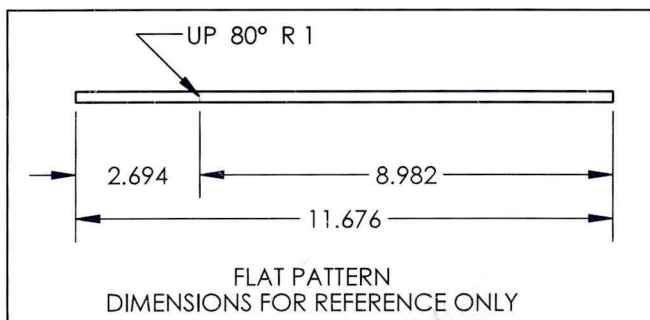
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REVISIONS				DATE	INITIAL	APPROVED
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NOTE:
REFERENCE EUROCOPTER T/N 105-14101W11.



DART AEROSPACE	
TITLE EXTRACTOR	
DWG NO. RBE105-14101W11	REV 1
MAT'L. 4140/4142 Q & T 1147 TREAT ZINC PLATE SPEC ASTM B633 TYPE I SC 2 DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL EC145	
SCALE 1:2	DATE 12/23/2015
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				2	EXTRACTOR	4140/4142 Q & T		